

Work Order ID 106611

September-10-13 11:23:45 AM

Asap

106611

Page 1

Item ID: D4695-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Channel

Start Date: 9/10/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *V* Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4695	B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

4 0 Jm13-09-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm13-09-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

B910

4 _____

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Item ID: D4695-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Channel

Start Date: 9/10/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00				4			8/13/09/11
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SHP 13-9-11		4			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	7/13-9-11		

Work Order ID 106611

106611

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September-10-13 11:23:45 AM

Item ID: D4695-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Channel
 Start Date: 9/10/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/11/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				4X			13/09/12
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 6-A Memo	0.00 0.00				4X			13/09/12
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/9/13

13/09/13

Picklist Print

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Page 1

Work Order ID: 106611

Parent Item: D4695-5

Parent Item Name: Channel

Start Date: 9/10/13

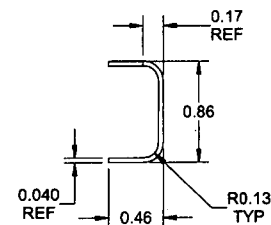
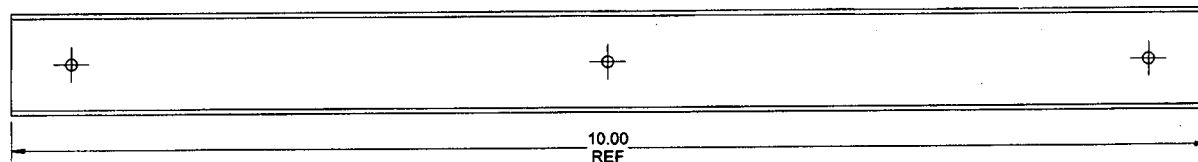
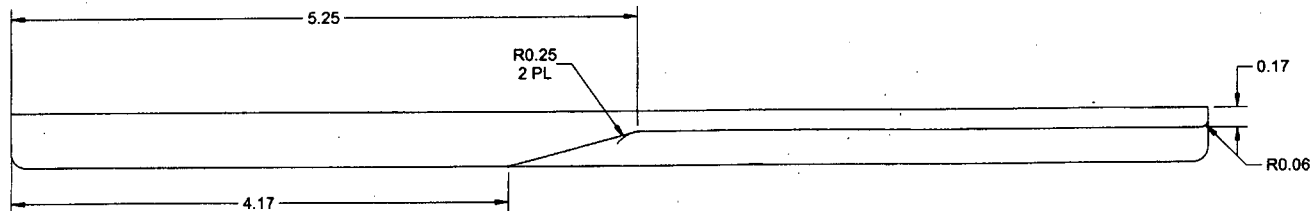
Required Date: 9/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	272.5670	0.109	0.4589474 1.0			Jm 1309-10
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		272.567							
				m126350		272.567			126350				



D4695-5 CHANNEL

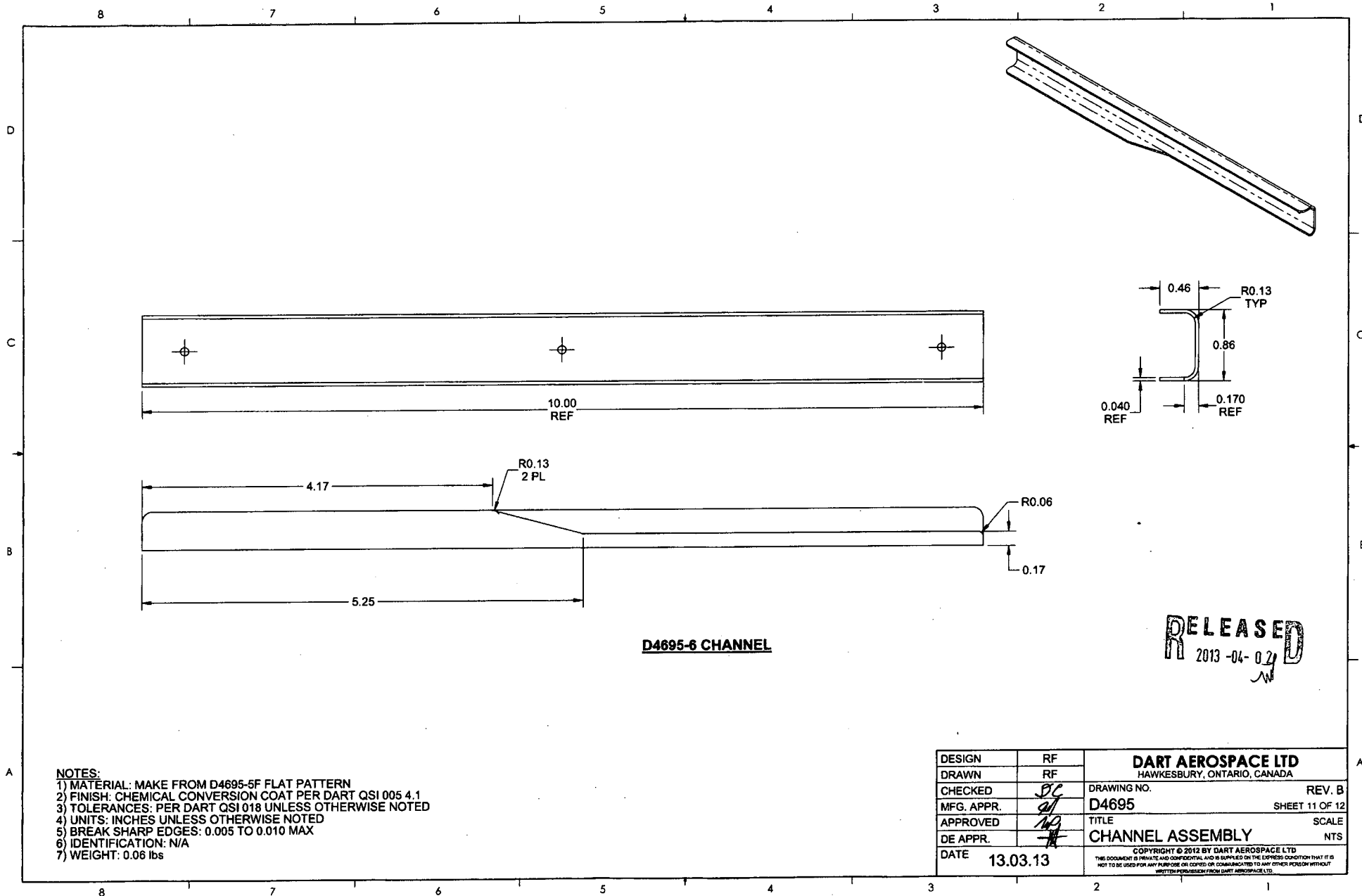
alocobell

RELEASED
2013-04-02

NOTES:

- 1) MATERIAL: MAKE FROM D4695-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

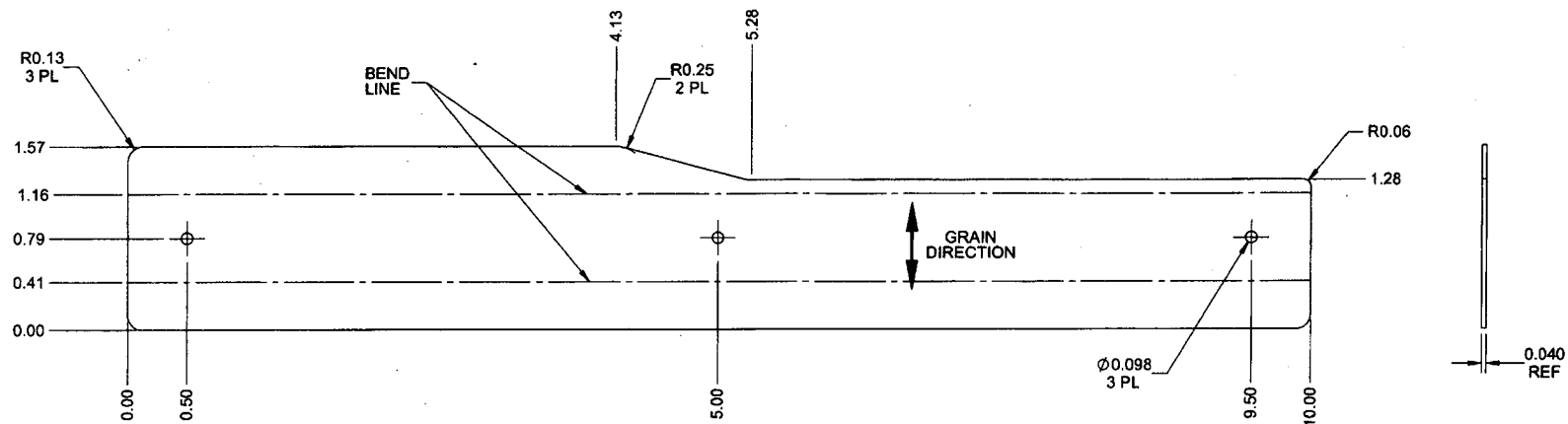
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SC</i>	D4695	SHEET 10 OF 12
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	CHANNEL ASSEMBLY	NTS
DATE	13.03.13	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	ST	D4695	SHEET 11 OF 12
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DE APPR.	TH	CHANNEL ASSEMBLY	NTS
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D4695-5F FLAT PATTERN CHANNEL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	21	D4695	SHEET 12 OF 12
APPROVED	49	TITLE	SCALE
DE APPR.	11	CHANNEL ASSEMBLY	NTS
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